

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017286**Date Inspected:** 11-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 250050 performing the Submerged Arc Welding process on weld 002 located at PCMK SEG3015. ABF QA Miss. Li Yun was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-U2c-s-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201215 performing the Flux Cored Arc Welding process on weld 003 located at PCMK SA3232-001. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2231-B-u2-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 002 located at PCMK AP3004-001. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044779 performing the Shielded Metal Arc Welding process on weld 124 located at PCMK 101. ZPMC QC Mr. Zhang Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P2212-Tc-u4b-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044772 performing the Shielded Metal Arc Welding process on weld 045 located at PCMK SEG3007H. ZPMC QC Mr. Zhang Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P2212-Tc-u4b-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067589 performing the Shielded Metal Arc Welding process on weld 046 located at PCMK SEG3007H. ZPMC QC Mr. Zhang Lin was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P2212-Tc-u4b-fcm.

### BAY # 16

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045280 performing the Flux Cored Arc Welding process on weld 132 located at PCMK LD3033-001. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-345-FCAW-2G (2F) Repair-1. Weld repair report identified as B-WR15659.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing Ultrasonic testing for the weld LD3034-001-155.

### BAY # 15

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, Member identified as SEG3019A-006. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Lv Li Qing was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-9601.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

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No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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